

Date: Tuesday, 13/05/2008 11:08:48 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 39240	
Estimate Number : 10008	
P.O. Number :	Part Number : D2591
This Issue : 13/05/2008 S.O. No. :	Drawing Number : D2591 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 38441	Material :
Written By :	Due Date : 05/06/2008 Qty: 100 Um: Each
Checked & Approved By : <u>JUL 08.5.13</u>	
Comment : Est Rev:1 Removed from 9 Digit 05-10-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"
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Comment: Qty.: 0.2340 f(s)/Unit Total: 23.4000 f(s)
 ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500)
 Batch: M108090

LF 08/05/22 23.4'

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.700" long

LF 08/05/22 (100)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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RG

issue R10 6425 meter

(100)

Comment: HAAS CNC VERTICAL MACHINING #1 machine per dwg D2591 REV. D
 1- Machine as per Folio FA 039 and Dwg D2591

2-Deburr if required

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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RG

read + inspect for hand-damage
ensure CMC attached

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

LF 06/12 (100)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

inspect level 5

LF 06/12

(100)

counters

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Pc 8/6/13

(150)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.06.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

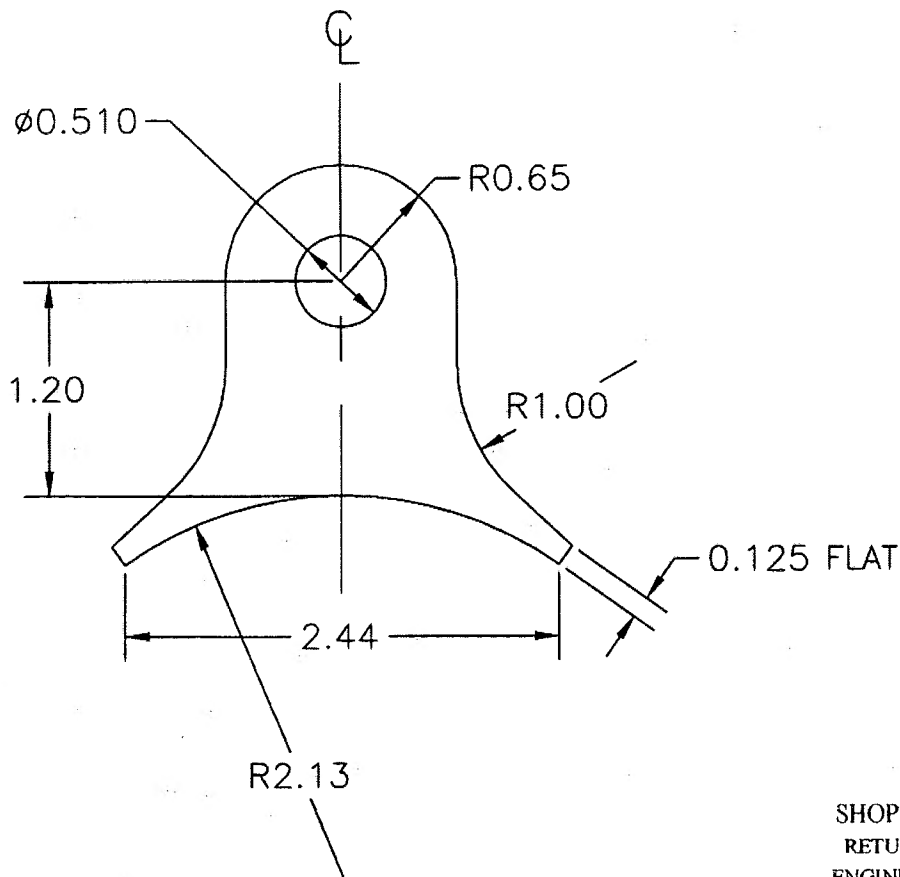
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>max</i>	DRAWN BY <i>max</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>B.S.</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96.09:16	NEW ISSUE	
B	97.06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED
98.01.21 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39240

BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~
MATERIAL: ASTM A36 STEEL 0.50 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTER-LINE
ALL DIMENSIONS ARE IN INCHES



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

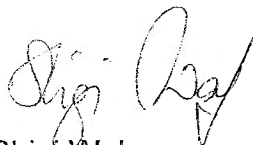
SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
100	D2591	Lug B39240	6425
	MATERIAL: supplied by DART M1010B0750X02500 M108090		

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, June 10, 2008